

Date: Tuesday, 21/11/2006 1:38:46 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FRAME
Job Number	: 29308A		
Estimate Number	: 10300	Part Number	: D32241
P.O. Number	: N/A	Drawing Number	: D3224 REV A
This Issue	: 21/11/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: 06/11/2006 Type : MACHINED PARTS	Material	: N/A
Previous Run	: 29148A	Due Date	: 30/11/2006 Qty: 2 Um: Each
Written By	: _____		
Checked & Approved By	: _____		
Comment	: Est Rev:A New Issue 05-11-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
Comment: Qty.: 5.4600 sf(s)/Unit Total : 10.9200 sf(s) 2024-T3 .063 thick aluminum sheet Batch: <u>m101022</u> <u>ml 06 12 08</u> (2)		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3224 Dwg Rev: <u>A</u> <u>ml 06 12 04</u> (2) Prog Rev: <u>A</u> 2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 06 12 04</u> (2)		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>ml 06 12 04</u> (2)		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>JAB 06 12 04</u> (2)		

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME

Job Number: 29308A

Part Number: D32241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3224

SR 07/01/11 (2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/11 (2)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SP 1 a.m 07/01/11 (2)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/12 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/01/12 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/15 (2)

Job Completion



07.01.15

Date: Monday, 11/6/2006 1:43:59 PM  
User: Kim Johnston

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FRAME
<b>Job Number</b> : 29308A	
<b>Estimate Number</b> : 10300	
<b>P.O. Number</b> :	<b>Part Number</b> : D32241
<b>This Issue</b> : 11/6/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3224 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 29148A	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 11/30/2006 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:A New Issue 05-11-06 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: \_\_\_\_\_

Email or Ship DXF file to vendor

Laser Cut D3224-1 flat pattern per Dwg D3224

Possible Supplier: GFI

Material release note is required

*Wzferjet*

2.0	D3224B	Frame
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**Comment:** Qty.: 1.0000 U(s)/Unit Total : 2.0000 U(s)  
Frame

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 1:43:59 PM  
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Drawing Name: FRAME

Job Number: 29308A

Part Number: D32241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3224

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

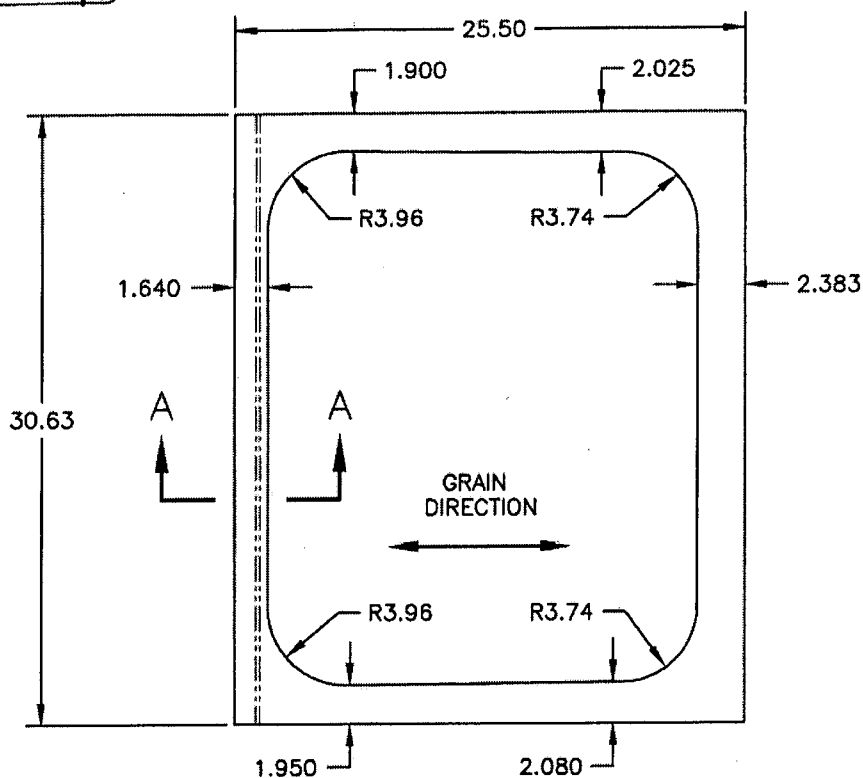
NOTE: Date & initial all entries



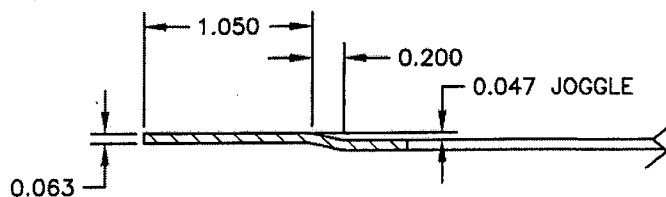


DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3224	REV. A SHEET 1 OF 1
DATE 03.10.21		TITLE FRAME	SCALE NTS
A	03.10.21	NEW ISSUE	

RELEASED  
04.02.03 [Signature]



D3224-1



SECTION A-A  
SCALE 8:1

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4), 0.063 THICK (REF. M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 29308A

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